

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002921**Date Inspected:** 31-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Sa Fa/ Wang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 3 – New Tower Building

The QA Inspector observed ZPMC qualified welder Xu Guoyin ID 05944 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP040-01 and DP041-001.

The QA Inspector observed two ZPMC personnel performing grinding on deck panel repairs, one welder performing FCAW welding on deck panel for repair of welds, one CWI Inspector, one personnel performing preheat of areas to be welded, and two ABF QC personnel identified as Kevin Chen and Ding Baohua.

The deck panel repair welding in the progress generally appeared to conform to contract specifications.

The QA Inspector was issued a notification to witness ZPMC perform final magnetic particle testing (MT) on deck panel weld repairs on the following: DP040-001, and DP041-001. The QA Inspector observed the ZPMC Technician Cai Xin Xin perform the MT.

The QA Inspector performed a final visual on the above listed deck panels and found various areas with weld profiles at repaired areas which did not appear to meet the contract requirement. ZPMC QC Mr. Fu Yuhong was

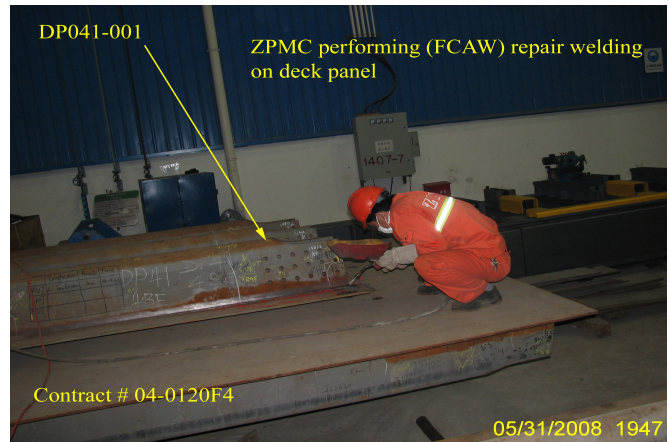
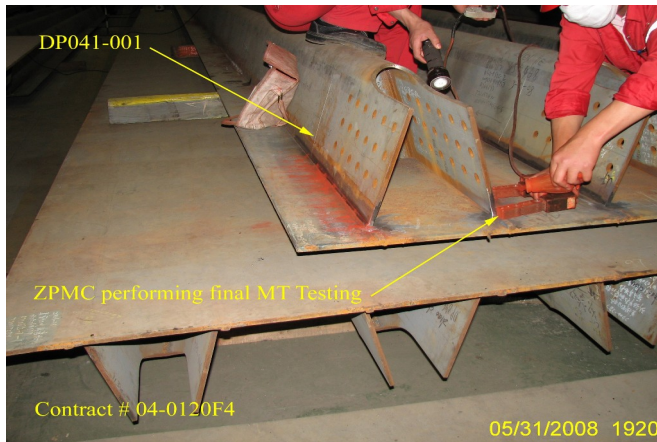
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informed and notified the CWI for tomorrow's shift to have the areas repaired by grinding to to correct the weld profile, and to notify Caltrans QA when grinding is completed.

The QA Inspector observed ZPMC personnel delivered and stored the following deck panels inside the New Tower Building # 3: DP029-001, DP042-001, DP043-001, and DP067-001.

The QA Inspector inventoried and located the following 35 deck panels in New Tower Building Bay #3 on this date: DP071-001, DP068-001, DP030-001, DP039-001 DP075-001, DP078-001, DP042-001, DP072-001, DP056-001, DP005-001, DP062-001, DP018-002, DP0014-002, DP039-001, DP056-001, DP080-001, DP037-001, DP038-001, DP042-002, DP041-001, DP037-001, DP040-001, DP001-001, DP006-001, DP006-001, DP001-002, DP053-002, DP055-01, DP049-001, DP038-002, DP077-001, DP074-001, DP054-001, DP052-001, DP003-001, DP007-001, DP080-001, DP038-001, DP026-001, DP050-001, DP065-001, DP042-001, DP043-001, DP029-001, DP067-001 and DP001-001.



Summary of Conversations:

As noted within the report shown above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Dixon, Roscoe	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
